

DART AEROSPACE LTD		Work Order: 23962
Description: <u>Sony ARM</u>		Part Number: <u>B67-43001-263</u>
Inspection Dwg: <u>B67-43001</u> Rev: <u>C</u>		Page 1 of 1

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FIRST ARTICLE INSPECTION CHECKLIST

☐

First Article

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Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.02	± 0.030	8.025	✓			
7.05	± 0.010	7.069	✓			
R.038	± 0.030	0.380	✓			
0.375		0.378	✓			
0.75	± 0.030	0.756	✓			
0.375	± 0.010	0.377	✓			
0.470	± 0.010	0.471	✓			
1.100	± 0.010	1.108	✓			
0.71	± 0.030	0.702	✓			
0.350	± 0.010	0.352	✓			
0.178	± 0.010	0.174	✓			
0.250	± 0.010	0.248	✓			
0.25	± 0.030	0.248	✓			
3.700	± 0.010	3.707	✓			
R.0.25	± 0.030	0.25	✓			
R.0.13	± 0.030	0.130	✓			
1.825	± 0.010	1.828	✓			

Measured by: <u>EP</u>	Audited by: <u>JMR</u>	Prototype Approval:
Date: <u>05/08/08</u>	Date: <u>05/08/08</u>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 04, 2005
03:24 pm

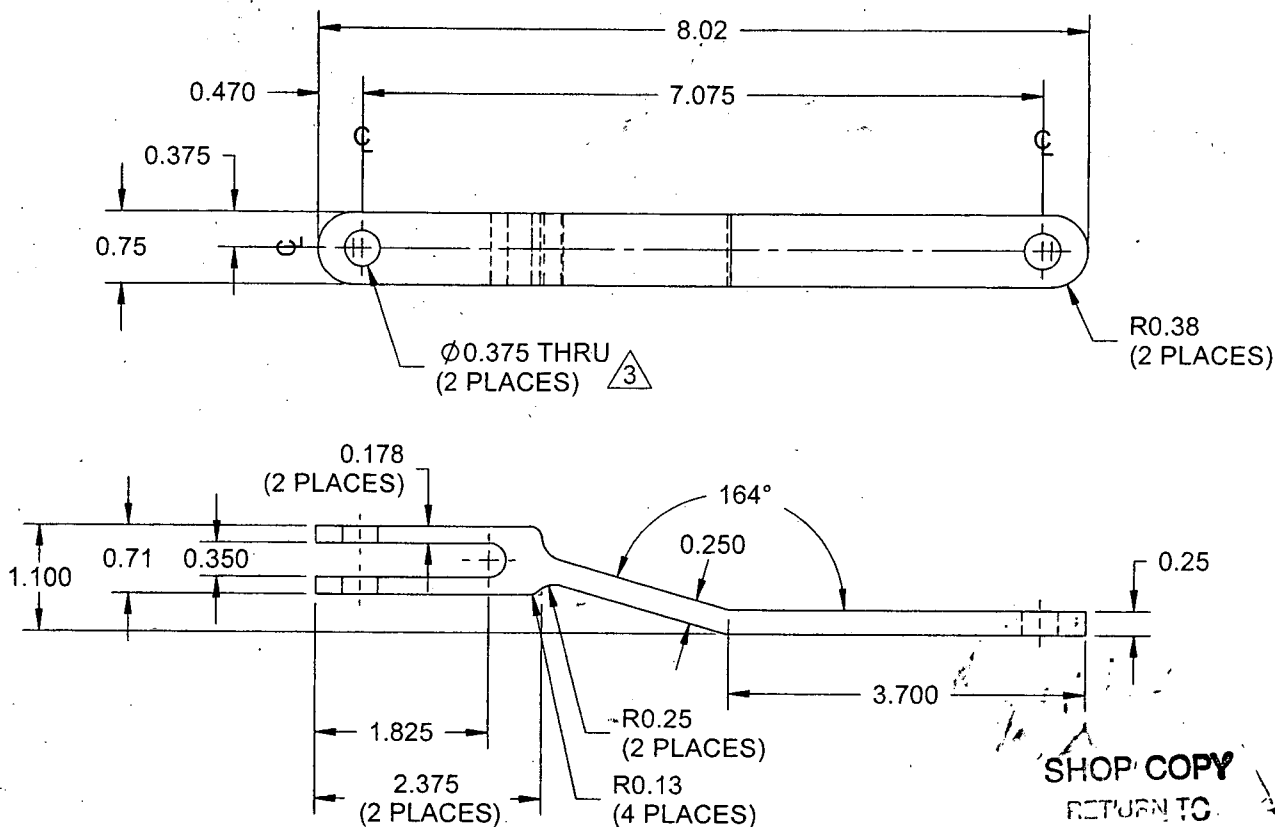
Work Order No	: 0023962	Department Code:	
Project Name	: pB67-43001-263	Burden Flags	: NNNNNNNN
Project For	: WK535	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: pB67-43001-263	Invoice Number	:
Description	: Swing Arm	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 75	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-04-05		
Est Finish Date	: 08-31-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. B67-43001-263	REV. C SHEET 1 OF 1
DATE	05.07.05		TITLE SWING ARM SCALE 1:2
C	05.07.05	NEW ISSUE	



B67-43001-263 SWING ARM

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) COVER INSIDE HOLES PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER
NO. 23962

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 05.08.31

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

SPLT

DART AEROSPACE LTD	Work Order:	23962 B
Description: Swing Arm	Part Number:	B67-43001-263
Dwg: B67-43001 Rev. B page 22	Qty:	13
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	LC	05.08.08	75
2	MV	Cut blanks: 1.500" x 1.500" x 8.400" long Material: 7075-T6 Bar (QQ-A-200/11) (M7075T6B1.500x01.500) Identify for B67-43001-263	Batch: 11018147 gml	05/08/08	75
3	MV	Machine as per Folio FA544 and Dwg B67-43001 Identify as B67-43001-263 Dwg Rev <u>2</u> Folio Rev <u>3</u>	Blk / SD / En	05.08.08	73/2
4	QC2	Inspect parts as they come off the CNC machine	Blk / SD / En	05.08.08	73/2
5	QC8	Second check	gml / Blk	05.08.08	73/2
6	MV	Deburr	Blk / SD / En	05.08.08	73/2
7	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05.08.23	73
8	FP	Powder Coat Green Sandtex (Ref: 4.3.8) as per QSI 005 4.3	FC	05.08.29	73
9	QC3	Inspect Powder Coat	ML	05.08.29	73
10	ST	Identify and Stock	CL	05.08.30	73
11	AC	Cost / part: 16.31	S4C	05.08.31	73
12	DC	Close W/O 16.31 Inspect Level 21	Blk	05.08.31	73

Rev	Date	Change	Revised By	Approved
A	05.07.19	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
05.08.19